

4

Date: Thursday, 11/29/2007 11:01:47 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 407 UTILITY BASKET
Job Number : 36019
Estimate Number : 10920
P.O. Number :
This Issue : 11/29/2007 S.O. No. :
Prsht Rev. : NC Part Number : D407663011
First Issue : 11 Type : LARGE FAB ASSY Drawing Number : D2955 REV B
Previous Run : 33017 Drawing Revision : B
Written By : Due Date : 1/20/2008 Qty: 1 Um: Each
Checked & Approved By :
Comment : Est Rev: 05.10.19 Added D2728-3 & AN960JD416L KJ/JL
M

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D407-663-011CHG002

08/09/04 07.12.12

2.0 36019A 407 BASKET BASE ASSEMBLY



Comment: Sub-Component 407 BASKET BASE ASSEMBLY

D2948-041 B 36019A

08/07/24

3.0 36019B 407 BASKET LID



Comment: Sub-Component 407 BASKET LID

D2952-041 B 36019B

08/07/24

4.0 PACKAGING 1 PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Assembly Kit

5.0 D2332041 Lid Prop Assembly 6.69"



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2332-041 Prop Ass 38797

08/07/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:01:47 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 36019

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2530

Handle Weldment



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 D2530 Handle Weldment

40211

AS

7.0

D2535

Spring



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2535 Spring

37071

AS

8.0

D2537

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2537 Bushing

39153

AS

9.0

D27283

Dart Logo label large



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2728-3 Label

22553

AS

10.0

D2851145

Placard



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

1 d2851-145 Placard

32019

AS

11.0

D2931

Bumper



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 D2931 Bumper

21139

AS 8/7/23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Drawing Name: 407 UTILITY BASKET

Job Number: 36019

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

12.0

D2961

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

1 D22961

Label

12077

AS

13.0

AN320A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN3-20A

Bolt

M15432

AS

14.0

AN414A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-14A

Bolt

M107534

AS

15.0

AN422A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN4-22A

Bolt

M107715

AS

16.0

AN517A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN5-17A

Bolt

M106815

AS

17.0

AN521A

Bolt



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number

Description Batch

2 AN5-21A

Bolt

M16463

AS

807/251

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:01:48 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 36019

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

18.0

AN960JD416

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD416 Washer

M107939

SS

19.0

AN960JD416L

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD416L Washer

M108138

SS

20.0

AN960JD516

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN960JD516 Washer

M107959

SS

21.0

AN960JD8

Washer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 AN960JD8 Washer

M107650

SS

22.0

AN9704

Washer



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 AN970-4 Washer

M108077

SS

23.0

MS20600AD4W3

Cherry Rivets



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

18071

SS

0807/2301

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 36019

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

2 MS20600AD4W3 Rivet

24.0

MS21042L3

Nut



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

2 MS21042L3 Nut (or -3) M67665

SS

25.0

MS21042L4

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L4 Nut (or -4) M67478

SS

26.0

MS21042L5

Nut



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick: Assembly Kit

Qty Part Number Description Batch

4 MS21042L5 Nut (or -5) M67939

SS

27.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Assemble basket as per Dwg D2955. Inspect for foreign objects as per QSI 024.

SS 08/07/24 @

28.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

SS 08/07/24 @

29.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Pick Packing Kit

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 36019

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

30.0

D2852

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

1 D2852

Label

33084

31.0

D2984

Label



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

1 D2984

Label

12605

32.0

D407301011

Center Bracket Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

1 D407-301-011 Center Bracket Kit

33400

33.0

D407302011

Outboard Bracket Kit



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

1 D407-302-011 Outboard Bracket Kit

33401

34.0

AN311A

Bolt



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

6 AN3-11A

Bolt

M14820

35.0

AN960JD10

Washer



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

.Qty Part Number Description Batch

6 AN960JD10

Washer

M108550

8/67/23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

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User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 UTILITY BASKET

Job Number: 36019

Part Number: D407663011

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

MS21042L3

Nut



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick: Packing Kit

.Qty Part Number

Description Batch

6 MS21042L3

Nut (or -3)

M107665

JS 08/07/23 (X)

37.0

QC4

INSPECT 100% KITS FOR COMPLETENESS



Comment: INSPECT 100% KITS FOR COMPLETENESS

JS 08/07/23 (X)

38.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and pack for shipping as per PPP D407-663-011

Location:

PPP Rev:

C

JS 08/07/23 (X)

39.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/24 JS

Job Completion



U 08/07/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN RF	DRAWN BY RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED #	APPROVED #	DRAWING NO. D2955	REV. B SHEET 1 OF 2
DATE 00.07.17		TITLE BASKET ASSEMBLY	SCALE NTS
A	00.01.13	NEW ISSUE	
B	00.07.17	UPDATE TOP VIEW OF BASKET	

Qty -041	Part Number	Description
X	D2955-041	BASKET ASSEMBLY
1	D2332-041	LID PROP ASSEMBLY
1	D2530	HANDLE WELDMENT
2	D2535	SPRING
2	D2537	BUSHING
1	D2851-145	PLACARD
1	D2961	PLACARD
2	D2931	BUMPER
1	D2948-041	BASKET BASE ASSEMBLY
1	D2952-041	BASKET LID ASSEMBLY
2	AN3-20A	BOLT
2	AN4-14A	BOLT
2	AN4-22A	BOLT
2	AN5-17A	BOLT
2	AN5-21A	BOLT
6	AN960JD416	WASHER
4	AN960JD516	WASHER
2	AN960JD8	WASHER
4	AN970-4	WASHER
2	MS20600AD4W3	RIVET
2	MS21042L3	NUT (OR MS21042-3)
4	MS21042L4	NUT (OR MS21042-4)
4	MS21042L5	NUT (OR MS21042-5)

#00.09.08
RF

#00.09.08
RF

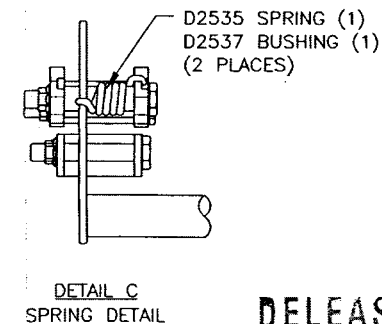
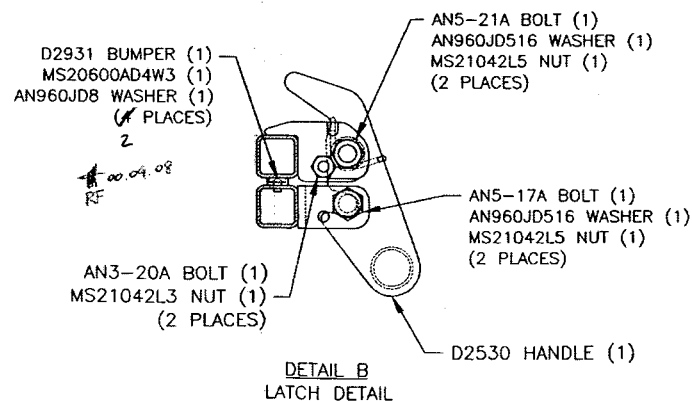
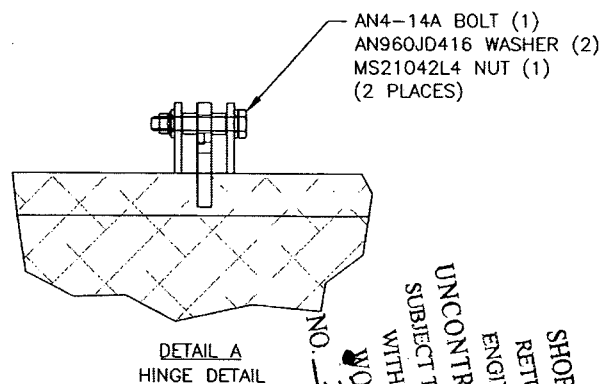
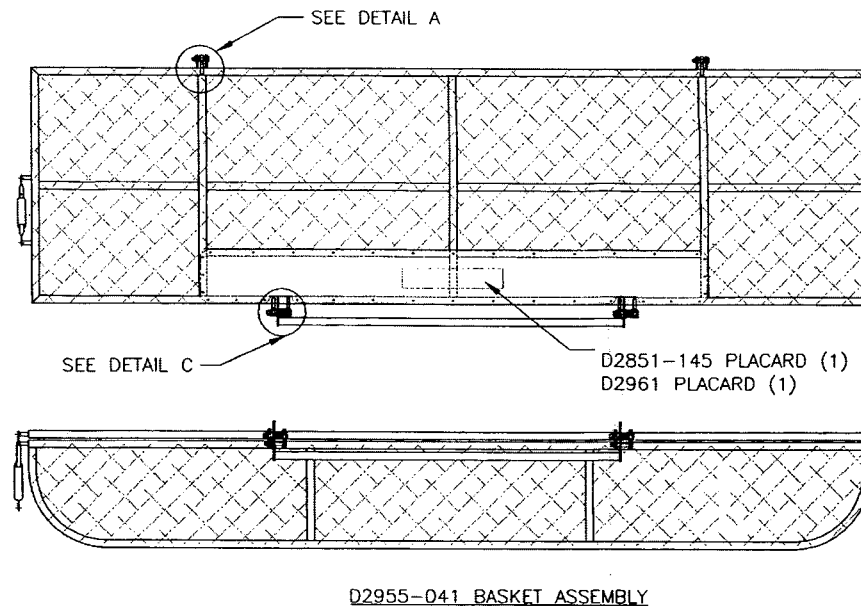
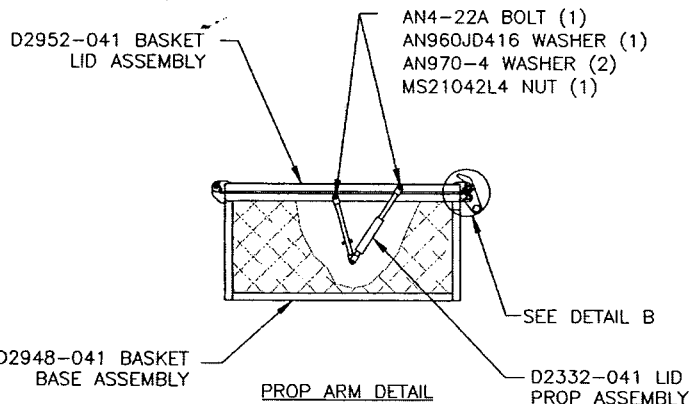
#00.09.08
RF

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 36013

RELEASED
00.07.18 #

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RELEASED
00.07.18

COPYRIGHT © 2000 BY DART AEROSPACE LTD.		DESIGN RF	DRAWN BY RF	DART	DART AEROSPACE LTD. HAMMERSBURY, ONTARIO, CANADA
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.		CHECKED RF	APPROVED RF	DRAWING NO. D2955	REV. B
DATE 00.07.17		TITLE BASKET ASSEMBLY		SHEET 2 OF 2	
				SCALE NTS	

NO. 30019

WORK ORDER

SUBJECT TO AMENDMENT
WITHOUT NOTICE

UNCONTROLLED COPY
ENGINEERING
RETURN TO
SHOP COPY

M19161
M103069

Dart Aerospace Ltd.

4

Date: Thursday, 11/29/2007 11:01:57 AM
User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : 407 BASKET BASE ASSEMBLY
Job Number : 36019A	
Estimate Number : 10912	
P.O. Number :	Part Number : D2948041
This Issue : 11/29/2007 S.O. No. :	Drawing Number : D2948 REV B
Prsht Rev. : NC	Project Number : N/A
First Issue : 1 / Type : LARGE FAB ASSY	Drawing Revision : B
Previous Run : 33017A	Material :
Written By :	Due Date : 1/20/2008 Qty: 1 Um: Each
Checked & Approved By : <u>[Signature]</u>	
Comment : Est Rev E 04.08.09 Revised Step 1 KJ/JLM	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
---------	-----------------------	---------------

1.0	M304TS0750W049	304 SQ Tube.75x.75x.049W
-----	----------------	--------------------------



✓
Comment: Qty.: 48.9993 f(s)/Unit Total : 48.9993 f(s)
Material: 304/316 SS tube 0.049" wall
(M304TS0.750W.049)
Batch: M107460

SAD

02/07/16

①

2.0	LANDING GEAR 1	LANDING GEAR RESOURCE 1
-----	----------------	-------------------------



Comment: LANDING GEAR RESOURCE 1

Cut (2) D2948-5, 3/4" x 3/4" 120" square tubing for bending as per Dwg D2948-5 B33017A ✓

2x

2x N/A Pull from stock

u of 2x16

3.0	BENDING	BENDING MACHINE
-----	---------	-----------------



Comment: BENDING MACHINE

Form D2948-5 as per Dwg D2948 using CNC bending program 407BASB and Folio FT019

4.0	QC5	INSPECT WORK TO CURRENT STEP
-----	-----	------------------------------



Comment: INSPECT WORK TO CURRENT STEP

5.0	D23273	Spacer Bushing
-----	--------	----------------



✓
Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
Pick:

Qty	Part Number	Description	Batch
1	D2327-3	Spacer	<u>337541</u>

08-07-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

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Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET BASE ASSEMBLY

Job Number: 36019A

Part Number: D2948041

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

D2581

Mounting Bracket



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number Description

Batch

2 D2581 Mounting Bracket

339046

Pl 08-07-21

7.0

D2954

Mounting Plate



Comment: Qty.: 4.0000 Each(s)/Unit Total : 4.0000 Each(s)

Pick:

Qty Part Number Description

Batch

4 D2954 Mounting Plate

312525

Pl 08-07-21

8.0

M304EX07516F

Expanded Metal Flat Stai



Comment: Qty.: 33.6000 sf(s)/Unit Total : 33.6000 sf(s)

Pick:

Qty Part Number Description

Batch

32sf M304EX0.75-16F SS Expanded Metal

M108152 (14.6)

M108474 (19)

SAD 08/07/17 ①

9.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Trim to length as per Dwg D2948 and Deburr/identify as D2948-5

2-Cut 3/4" x 3/4" square tubing as per Dwg D2948

Identify properly as D2948-1/-3/-7/-9

3-Remove all Markings From Material.

4-Weld as per Dwg D2948 and QSI 004. Deburr as required.

A/R SS Rod

Batch: M106762

SAD 08/07/16 ②

Pl 08-07-21

10.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

Pl 08-07-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Date: Thursday, 11/29/2007 11:01:58 AM

User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET BASE ASSEMBLY

Job Number: 36019A

Part Number: D2948041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

808/4/22 40

12.0

POWDER COATING

POWDER COATING



M108523



(1X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1

08/07/22

13.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

bf

08-07-22

14.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: 6-A

08/07/23 @

15.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/24

Job Completion



U 08.07.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

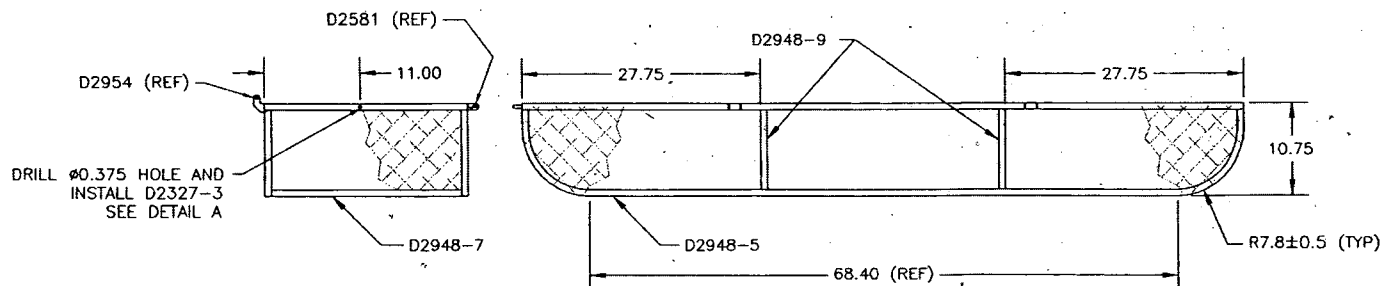
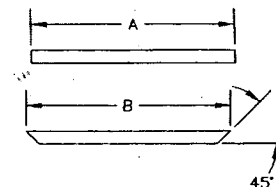
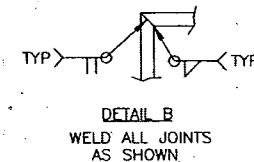
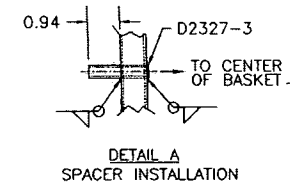
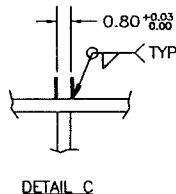
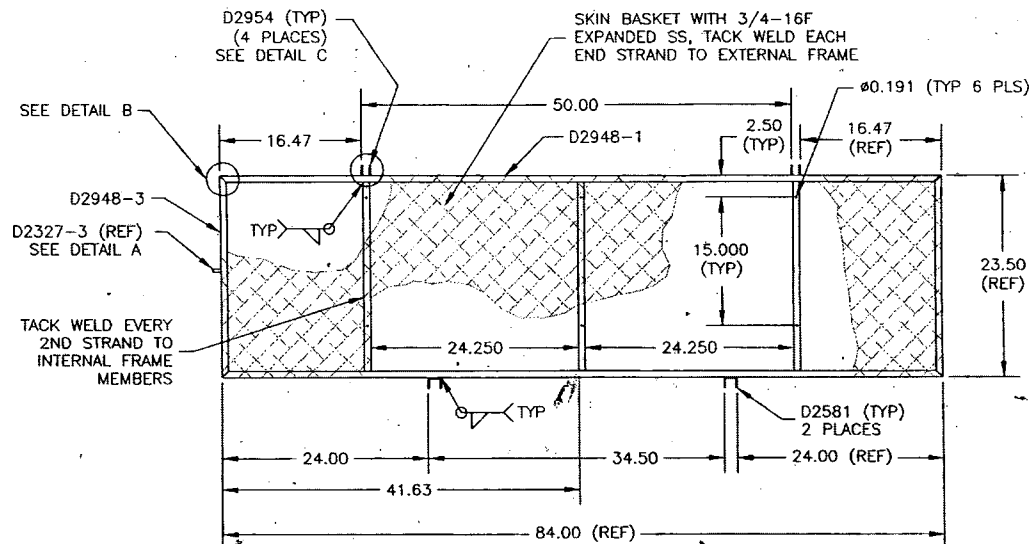
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
00.07.18



QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
-041				
X	D2948-041	BASKET ASSEMBLY	N/A	N/A
2	D2948-1	FRAME MEMBER	N/A	84.00
2	D2948-3	FRAME MEMBER	N/A	23.50
2	D2948-5	FRAME MEMBER	95.97	N/A
3	D2948-7	FRAME MEMBER	22.00	N/A
4	D2948-9	FRAME MEMBER	9.25	N/A
1	D2327-3	SPACER	N/A	N/A
2	D2581	MTG BRACKET	N/A	N/A
4	D2954	MOUNTING PLATE	N/A	N/A

FRAME MATERIAL: AISI 304/316 SS, 3/4 x 3/4 x 0.049 WALL SQUARE TUBING
MESH MATERIAL: 3/4-16F EXPANDED SS
FINISH: POWDER COAT WHITE (REF. 4.3.5.2) PER DART QSI 005 4.3
WELD PER DART QSI 004
TOLERANCES ARE PER DART QSI 008 UNLESS OTHERWISE NOTED

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B	00.07.17	ADD Ø0.191; R7.8 WAS R6.8
A	00.01.12	NEW ISSUE
DESIGN	RF	DRAWN BY RF
CHECKED	RF	APPROVED RF
DATE	00.07.17	TITLE BASKET BASE ASSEMBLY
		DART AEROSPACE LTD. HARRISBURG, ONTARIO, CANADA
		DRAWING NO. D2948
		REV. B SHEET 1 OF 1
		SCALE NTS

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WITHOUT NOTICE
WORK ORDER
36029A

Date: Thursday, 11/29/2007 11:02:10 AM
 User: Kim Johnston

Process Sheet

4

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 407 BASKET LID
 Job Number : 36019B
 Estimate Number : 10917
 P.O. Number :
 This Issue : 11/29/2007 S.O. No. :
 Prsht Rev. : NC
 First Issue : 1 / Type : LARGE FAB ASSY
 Previous Run : 33017B
 Written By :
 Checked & Approved By : Jim H 29
 Comment : Est Rev: 03.11.26 Reformat KJ/RF

Part Number : D2952041
 Drawing Number : D2952 REV B
 Project Number : N/A
 Drawing Revision : B
 Material :
 Due Date : 1/20/2008 Qty: 1 Um: Each

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6TS0750W062 6061-T6 SQ Tube.75x.062W



Comment: Qty.: 39.3750 f(s)/Unit Total : 39.3750 f(s)
 Material: 6061-T6 (QQ-A-200/8 or QQ-A-225/8) 0.062" wall
 (M6061T6TS0.750W.062)
 Batch: M104422

SAD 08/07/16

①

2.0 M5052H32S080 5052-H32 .080 Sheet



Comment: Qty.: 0.0656 sf(s)/Unit Total : 0.0656 sf(s)
 Material: 5052-H32/H34 (QQ-A-250/11 or QQ-A-250/8) 0.080"
 (M5052H32S.080) or 6061T6S080 (M6061T6S080)
 Batch: M106320
 Identify as D2952-11

Pl 08.07.21

3.0 D2953077 Spacer



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 2 D2953-077 Spacer 336032 → 3

Pl 08.07.21

(P10) →

4.0 D2953175 Spacer



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)
 Pick:
 Qty Part Number Description Batch
 1 D2953-175 Spacer 322096

Pl 08.07.21

Dart Aerospace Ltd

W/O: 36019B		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2952-041 PAR #: NA Fault Category: Small Large Fats NCR: Yes No DQA: D Date: 08/07/09
D407 763 011 QA: N/C Closed: D Date: 08/07/09

NCR: 36019B		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/7/08	30	one D2953-077 melted Dunn welding. P.C. welder touched Bushin first not mounting plate when taking	<i>[Signature]</i> 08/07/08	Scrap Bushin Replace	<i>[Signature]</i> 08/07/08	<i>[Signature]</i> 08/07/08	<i>[Signature]</i> 08/07/08	<i>[Signature]</i> 08/07/08

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:02:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET LID

Job Number: 36019B

Part Number: D2952041

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

D2957

Mounting Plate



Comment: Qty.: 6.0000 Each(s)/Unit Total : 6.0000 Each(s)

Pick:

Qty Part Number Description Batch

6 D2957 Mounting Plate B36399

Cpl 08-07-21

6.0

M1100H14ES34X051F

Alum Expanded Metal



Comment: Qty.: 15.7500 sf(s)/Unit Total : 15.7500 sf(s)

Pick:

Qty Part Number Description Batch

15sf M1100H14ES-3/4x.051F Mesh 15444

SAD 08/07/21

7.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Cut D2952-11 corner gussets as per Dwg D2952

2-Drill holes in D2952-3 as per Dwg D2952.

SAD 08/07/16

(1)

3- Deburr & Remove any Markings From Material

4-Weld as per Dwg D2952 as per QSI 004. Deburr as required

A/R AL ROD Batch: M104855

Cpl 08-07-21

8.0

QC9

VISUAL WELDING INSPECTION



Comment: VISUAL WELDING INSPECTION

ID 0807-22 (1)

9.0

QC6

DIMENSIONAL CHECK



Comment: DIMENSIONAL CHECK

6 0807/22 (1)

10.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

F.D.M.
[Signature]

08/07/22

(18)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Thursday, 11/29/2007 11:02:10 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 407 BASKET LID

Job Number: 36019B

Part Number: D2952041

Job Number:



Seq. #:

Machine Or Operation:

Description :

11.0

D2983

Label Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)
Label Plate **B32023**

Pl 03.07.22

12.0

MS20600AD4W2

Rivet



Comment: Qty.: 34.0000 Each(s)/Unit Total: 34.0000 Each(s)
Rivet **M106513**

Pl 03.07.22

13.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

S 08/07/22

14.0

LARGE FAB 1

LARGE FABRICATION RESOURCE 1



Comment: LARGE FABRICATION RESOURCE 1

1-Assemble Label Plate as per Dwg D2952

Pl 08.07.22

15.0

POWDER COATING

POWDER COATING



M108523



(14)

Comment: POWDER COATING
Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

m-l 08/07/23

16.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

Pl 08-07-23

17.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock
Location: **G-A**

Pl 08/07/23

18.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08/07/24

Job Completion



12 08.07.24

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

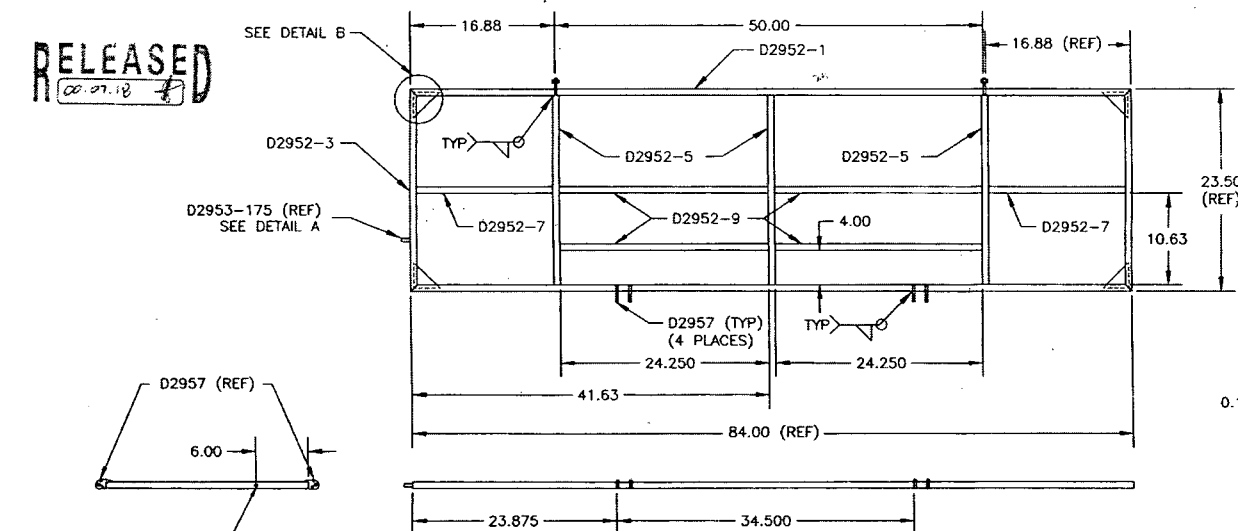
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

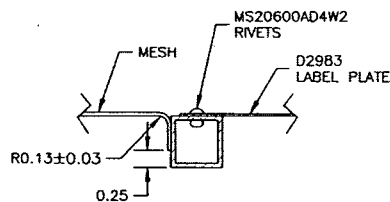
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DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

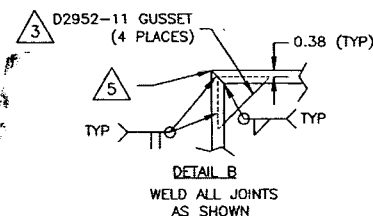
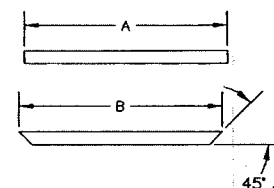
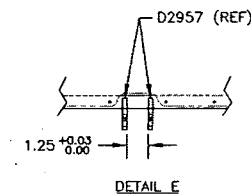
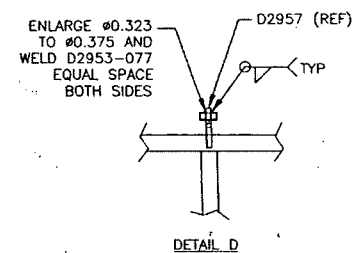
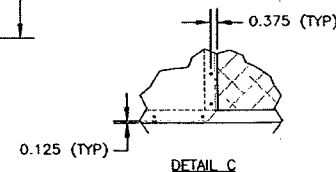
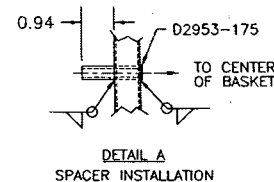
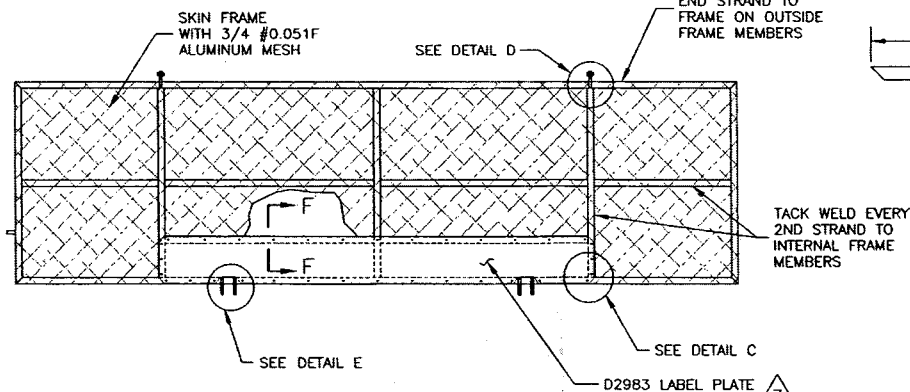
RELEASED
00-07-12



DRILL $\phi 0.375$ HOLE
AND INSTALL D2953-175
SEE DETAIL A



SECTION F-F



NOTES:

- 1) FRAME MATERIAL: 6061-T6, 3/4 x 3/4 x 0.065 WALL SQUARE TUBING (QA-A-200/8 OR QA-A-225/8)
- 2) MESH MATERIAL: 5005-H34 OR 3003-H14 OR 1100-H14/H18 3/4 $\phi 0.051$ F
- 3) GUSSET MATERIAL: 6061-T6 (QA-A-250/11) OR 5052-H32/H34 (QA-A-250/8) (3.00 x 3.00) 0.080 THICK
- 4) WELD PER DART QSI 004
- 5) GRIND 0.063 MAX x 45° CHAMFER BEFORE WELDING CORNERS (TYP. 4 PLACES)
- 6) GRIND WELDS FLUSH ON TOP SIDE FOR LABEL PLATE, GRIND CORNER WELDS (4 PLS) BOTTOM SIDE FOR GUSSET
- 7) TRANSFER D2983 LABEL PLATE HOLES USING $\phi 0.128$ DRILL. INSTALL D2983 ONTO FRAME USING MS20600AD4W2 RIVETS (TYP. 34 PLACES)
- 8) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT WHITE (REF. 4.3.5.1) PER DART QSI 005 4.3
- 9) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

QTY	PART NUMBER	DESCRIPTION	LENGTH A	LENGTH B
-041				
X	D2952-041	BASKET LID ASSEMBLY	N/A	N/A
2	D2952-1	FRAME MEMBER	N/A	84.00
2	D2952-3	FRAME MEMBER	N/A	23.50
3	D2952-5	FRAME MEMBER	22.00	N/A
2	D2952-7	FRAME MEMBER	15.88	N/A
4	D2952-9	FRAME MEMBER	24.25	N/A
4	D2952-11	GUSSET	N/A	N/A
1	D2953-175	SPACER	N/A	N/A
2	D2953-077	SPACER	N/A	N/A
6	D2957	MOUNTING PLATE	N/A	N/A
1	D2983	LABEL PLATE	N/A	N/A
34	MS20600AD4W2	RIVETS	N/A	N/A

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B	00.07.06	CHANGE FROM SHEET TO MESH; ADD D2952-7/-9/-11
A	00.01.14	NEW ISSUE
DESIGN RF	DRAWN BY RF	DART DART AEROSPACE LTD. HAMPSHIRE, ONTARIO, CANADA
CHECKED #	APPROVED #	DRAWING NO. D2952
DATE 00.07.06		TITLE BASKET LID ASSEMBLY
		REV. B SHEET 1 OF 1 SCALE NTS

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